



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-675-111
Job Sheet 186318



Part No: D119-675-111

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - DART Crosstube Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

6490

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/21/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		11/21/18	0.00	0.00	Packaging1-1		DAS 1 8 2019
120	QC	1 pcs		11/21/18	0.00	0.00	QC4		DAS 1 8 2019
130	Packaging	1 pcs		11/21/18	0.00	0.00	Packaging3-1		DAS 1 8 2019
135	DC	1 pcs		11/21/18	0.00	0.00	DC		DAS 1 8 2019
140	QC21-FG	1 Ea		11/21/18	0.00	0.00	QC21		DAS 1 8 2019

Part Op 130 - Identify and pack for shipping as per PPP D119-675-111 Location : FG107
Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-675-111 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	4 Ea (4 ea)	90-Start up Operation	5107130
AN4-16A	Bolt	4 Ea (4 ea)	90-Start up Operation	5127432
AN4-22A	Bolt	4 Ea (4 ea)	90-Start up Operation	5097470
D2617-3	Bushing	4 Ea (4 ea)	90-Start up Operation	5116369X1 5137506X1
D2617-5	Spacer	4 pcs (4 ea)	90-Start up Operation	5140822
D2732-032	Rubber Cushion - 3.2"	8 Ea (8 ea)	90-Start up Operation	5105035
D5283-041	Basket Clamp Assembly	2 Ea (2 ea)	90-Start up Operation	5102741
D5283-043	Basket Clamp Assembly	2 Ea (2 ea)	90-Start up Operation	508519X1 5109625X1
D5283-11	Basket Clamp	2 Ea (2 ea)	90-Start up Operation	5116156
D5283-7	Basket Clamp	2 Ea (2 ea)	90-Start up Operation	5116079X1 5116111X1
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5107736
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	5092780
D3043-041	Step Weldment LH	1 Ea (1 ea)	110-Packaging	5163875

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	4	139	0
	AN4-16A	4	472	0
	AN4-22A	4	147	0
	D2617-3	4	11	0
	D2617-5	4	15	0
	D2732-032	8	46	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																						
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OTHER :				Completed By _____ / Supervisor Verification Coordinator _____ Eval _____ DART Aerospace Ltd. 1270 Aberdeen Street 1K7 Haverbury, ON K0A 1K7 Canada Tel: 1 613 632-6200 Email: sales@dartaero.com www.dartaero.com																																																										

D5283-041	2	14	0
D5283-043	2	17	0
D5283-11	2	46	0
D5283-7	2	41	0
MS21042L4	12	1,976	0
NAS1149D0463J	24	2,807	0
D3043-041	1	1	0
110-Packaging			
Part Specifications			
Specifications could not be found.			

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REFERENCE ONLY

5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: C

Date: 15.07.20

Change Record

PAGE 1 OF 1

Part Number: D119-675-111/-112

Description: HELI ACCESS STEP, LH/RH

[illegible]